

Work Order ID 63552

Thursday, November 04, 2010 10:03:22 AM



Page 1

Item ID:	D3065-5	Accept		Setup	Start	
Revision ID:						
Item Name:	Step Leg				Stop	
Start Date:	11/4/2010	Start Qty: 40.00		Cust Item ID:		
Required Date:	11/19/2010	Req'd Qty: 40.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>H</u>	Date:	<u>10-11-04</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3065	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	I-Cut as per Dwg D if necessary		<input checked="" type="checkbox"/> Dwg Rev: <u>B</u>	<input type="checkbox"/> Prog Rev: <u>B</u>	<input type="checkbox"/> 2-Deburr				
6061 .080									

B 10-12-02

40

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B 10-12-02

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

5012/22

count
(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Page 2

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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00		10/12/22		40	0		
Hand Finishing									
140  QC	QC3- Inspect Part Finish	0.00							
	Memo	0.00							
Quality Control									
150  Packaging	Identify as per dwg & Stock Location:	0.00							
	Memo	0.00							
Packaging									

40 10/12/22

11/12/22 40

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Page 3

Item ID: D3065-5

Accept



Setup Start



Revision ID:

Item Name: Step Leg

Stop



Start Date: 11/4/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/23

28-10-12-23
40

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, November 04, 2010 10:03:26 AM

Page 1

Work Order ID: 63552

Parent Item: D3065-5

Parent Item Name: Step Leg



Start Date: 11/4/2010

Required Date: 11/19/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐C☐02.11.01☐Incorporated D3066-1 IPP☐KJ/RF
 IPP Rev:D Now on Water Jet 06-04-11 JLM
 IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080		Purchased	No			100	sf	10.7162	0.825	34.73684			
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6061-T6 .080 Sheet



B10-12-02

Location

Loc Qty

Loc Code

MAT

10.715

115689

10.715

MAT21

0.0012

113438

0.0012

116268

116268

40

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68552
Description: Step Leg		Part Number:	D3065-5
Inspection Dwg: D3065 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.458	✓		T B01	
15.750	+/-0.005	15.750	✓		T	
2.250	+/-0.005	2.248	✓		V B02	
3.460	+/-0.005	3.461	✓		V	
0.865	+/-0.005	.867	✓		V	
6.020	+/-0.005	6.020	✓		V	
1.205	+/-0.005	1.205	✓		V	
3.484	+/-0.005	3.486	✓		V	
0.871	+/-0.005	.870	✓		V	
8.325	+/-0.010	8.328	✓		V PRO B02	
0.551	+/-0.010	.553	✓		V	
0.213	+0.005/-0.000	.215	✓		V	
Ø0.128	+0.005/-0.000	.133	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-12-22	Date: 10/12/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

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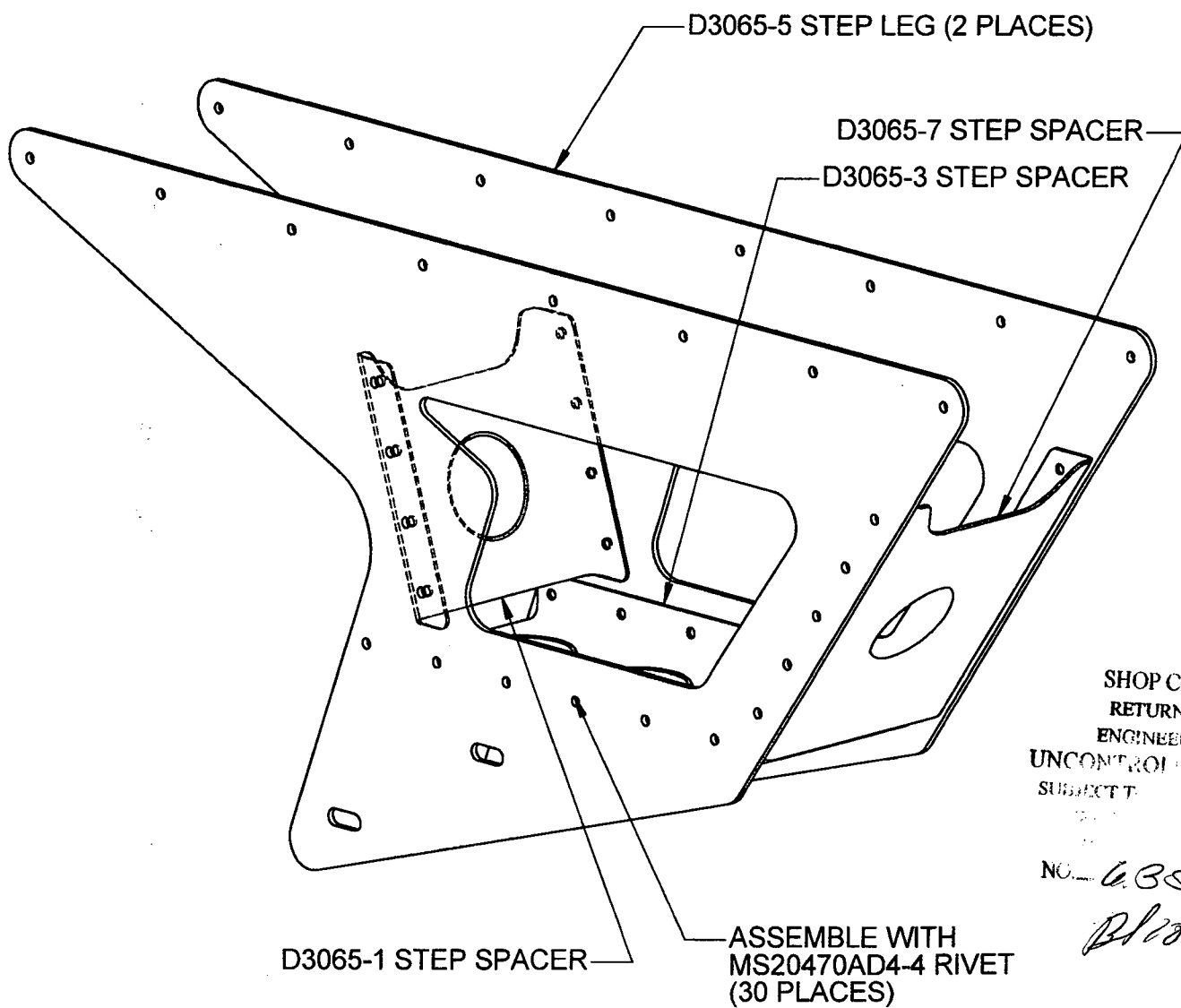
NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06-06-20



SHOP COI
RETURN T
ENGINEER
UNCONTROL
SUBJECT T

NO. *03582*
01011-04

D3065-041 STEP LEG ASSEMBLY

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

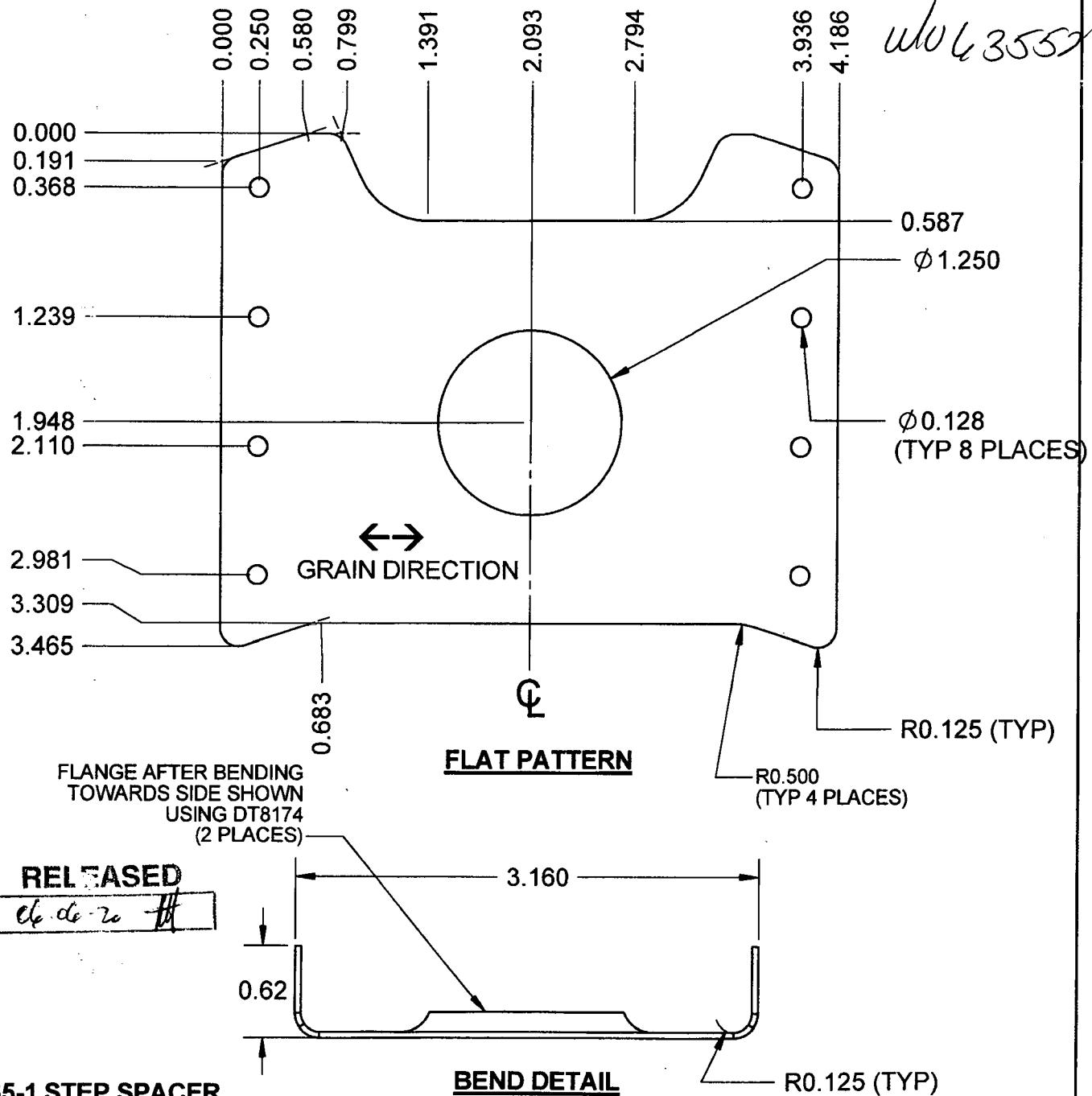
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

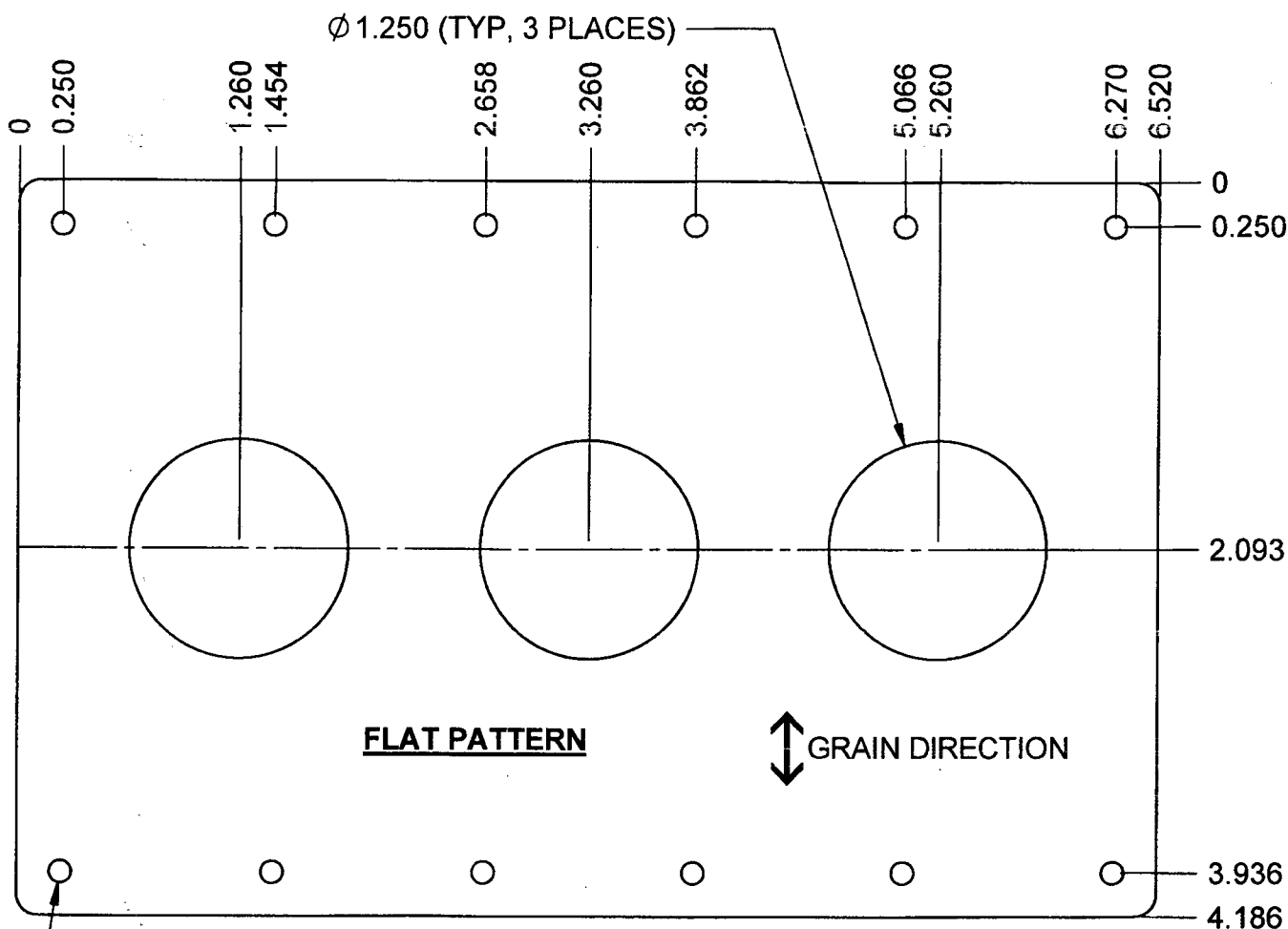
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

W1043532

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

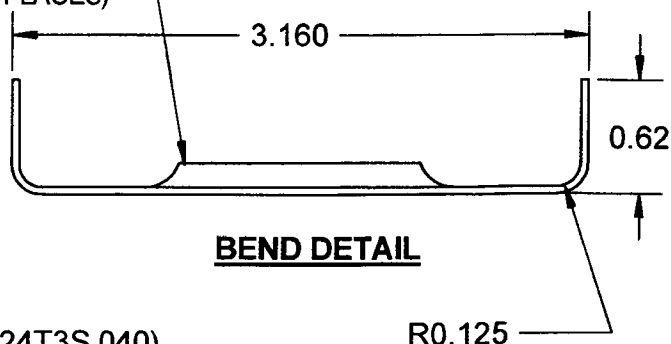


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

$\phi 0.129$ (TYP, 12 PLACES)

RELEASED

06 dec 20 *[Signature]*



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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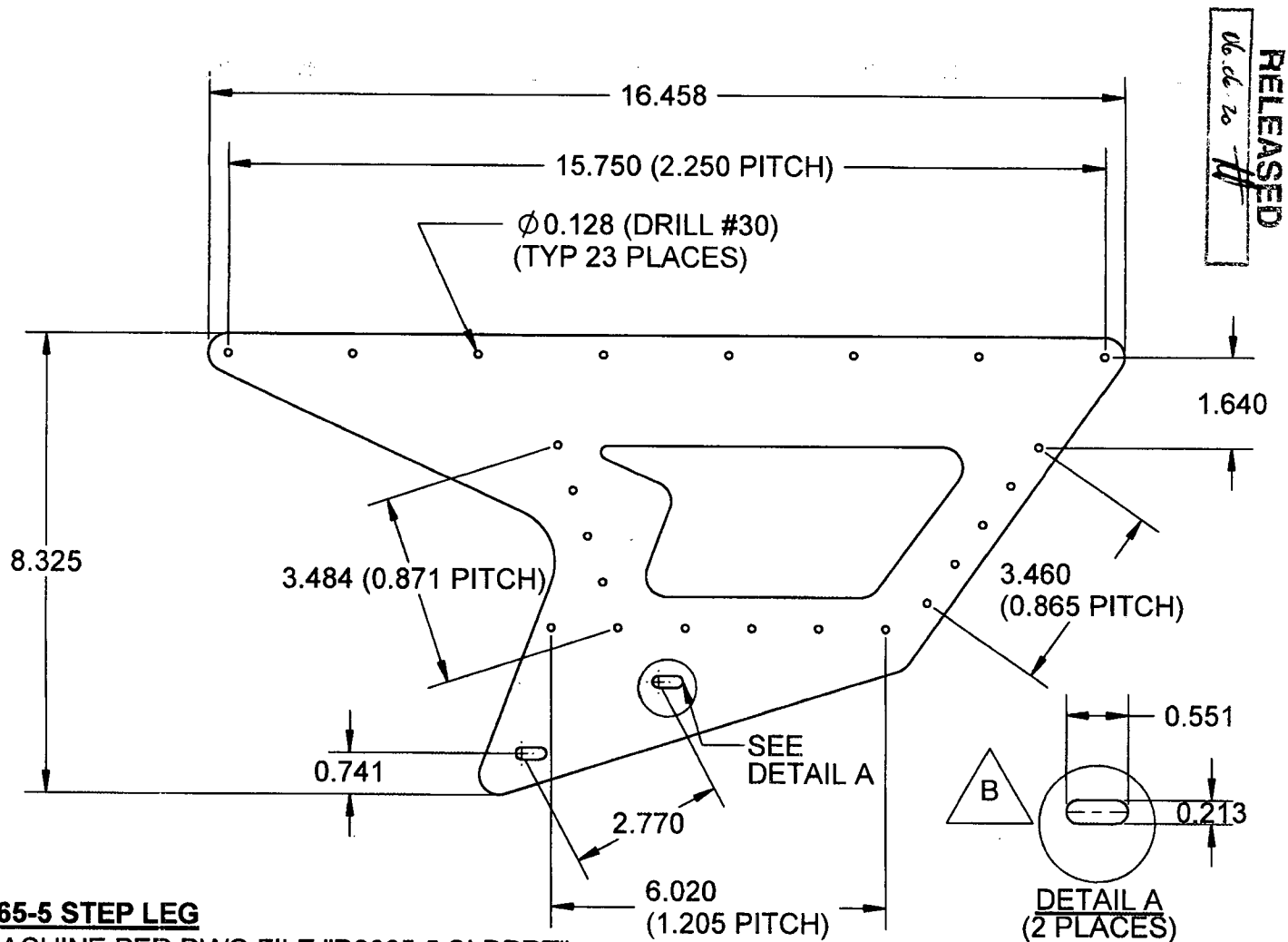
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NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
06.05.23	D3065	REV. B
DATE	TITLE	SHEET 4 OF 5
	STEP LEG ASSEMBLY	SCALE 1:3

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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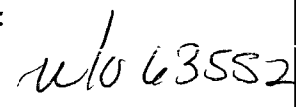
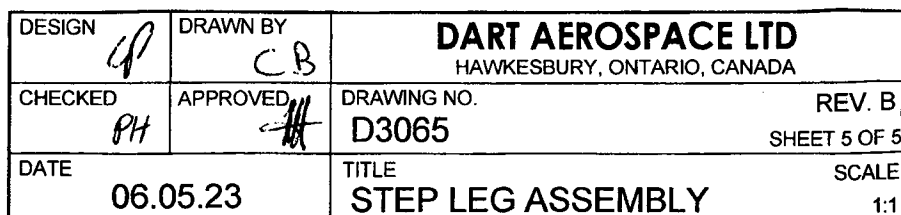
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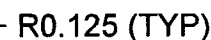
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NOTE: Date & initial all entries



06 06 20



1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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